

Work Order ID 57726

April 14, 2010 10:32:25 AM



Page 1

Item ID: D3405-041

Accept



Setup Start



Revision ID:

Item Name: Lug Assembly

Stop



Start Date: 14/04/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 22/04/2010 --Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan: 14

Date: 10-4-14

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3405	Rev B								

100.



FLOW WATER JET

0.00

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3405

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

304 .125

10-4-15

(12)

110



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

10-4-15

120



QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

Scot 1/16

(412)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Brake NC

NC BRAKE

0.00

Memo

0.00

Deburr

Form using DT8204 as per Dwg D3405

SS 10/4/20

12

0

140



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

81064/20

12

0

Quality Control

150



Large Fab

Large Fab

0.00

Memo

0.00

Weld as per Dwg D3405
Identify as D3405-041

EL 10-4-26

12

0

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Cust Item ID:

Required Date: 22/04/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

Pl 10.04.28

170

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Discolor

(X12)

180

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00



Powdercoat

1114207

0.00

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8:30 AM

400 °F

8:00 AM

=> 14/10/04/30

X12

Ø

Powder Coating

W/O:		WORK ORDER CHANGES					
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Page 4

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Required Date: 22/04/2010 Req'd Qty: 12.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

12 BR 10-4-30

200

Identify as per dwg & Stock Location: 474

0.00



Packaging

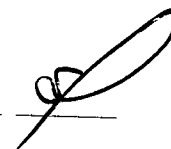
Memo

0.00

Packaging



10-5-9



210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/04

U 10/05/04

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NOTE: Date & initial all entries

Picklist Print

April 14, 2010 10:32:29 AM

Page 1

Work Order ID: 57726

Parent Item: D3405-041

Parent Item Name: Lug Assembly

Comments: IPP A 05.09.01 New issue KJ/JLM
IPP B 09.01.28 rev.B drawing EC verified by:DD

Start Date: 14/04/2010

Required Date: 22/04/2010

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3404-1



GHW Lug

Manufactured

No

100

Each

20.0000

12.0000



22

10-4-27

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

20

56832

20

150

sf

25.3100

1.9453



10-4-15

M304S11GA



304/316 0.125 Sheet

Purchased

No

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT19

25.31

112663

25.31

112663

12

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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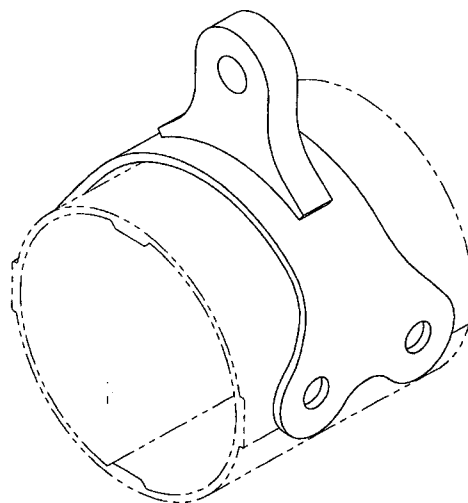
NOTE: Date & initial all entries

ITEM No.	QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION
1	X		D3405-041	LUG ASSEMBLY
2		X	D3405-043	LUG ASSEMBLY
11	1	1	D3404-1	GHW LUG
12	1		D3405-1	GHW BRACKET
13		1	D3405-3	GHW BRACKET

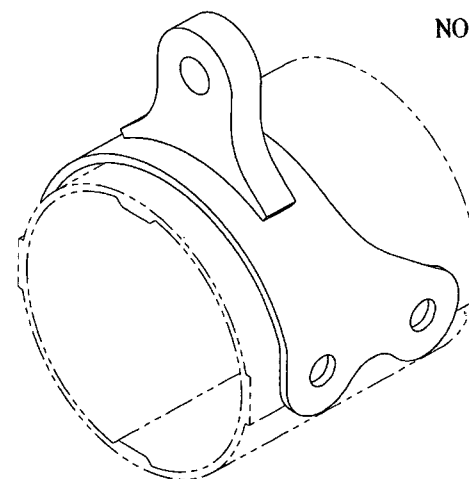
△B

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 57726

B810-4-14



D3405-041 LUG ASSEMBLY
(SKID TUBE SECTION SHOWN
FOR REF ONLY)



D3405-043 LUG ASSEMBLY
(SKID TUBE SECTION SHOWN
FOR REF ONLY)

RELEASED
08/12/18

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3405-041" USING FINE POINT PERMANENT INK MARKER
IDENTIFY WITH DART P/N "D3405-043" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: -041, 0.85 lbs
-043, 0.87 lbs

B	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. FLAT PATTERNS FOR -1 & -3 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR199). SHEETS 3 & 4 ZONE A6 4.120 DIM WAS 4.100.		AJS	08.09.19
A	NEW ISSUE		PH	05.03.08
REV.	DESCRIPTION		BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED		DRAWING NO.	REV. B	
MFG. APPR.		D3405	SHEET 1 OF 4	
APPROVED		TITLE	SCALE	
DE APPR.		GHW LUG ASSEMBLY	NTS	
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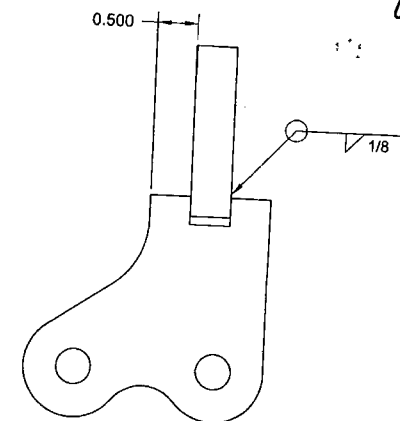
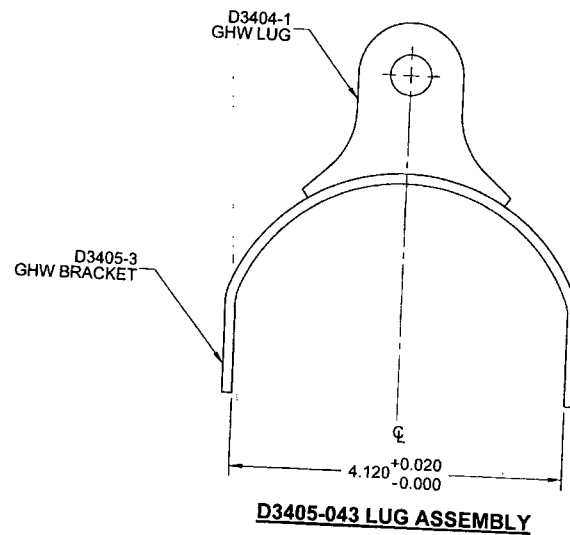
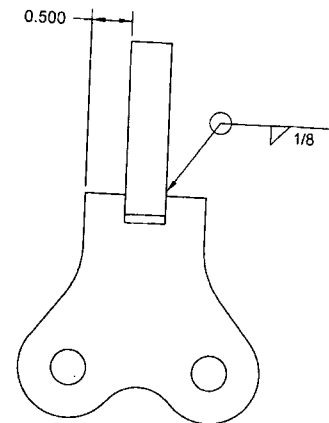
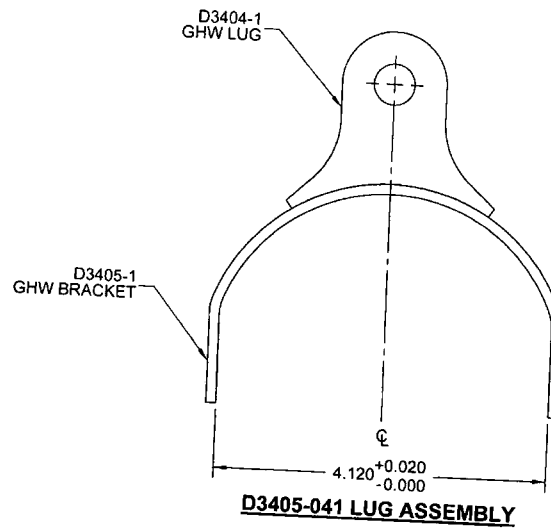
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08/12/18

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DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3405	SHEET 2 OF 4
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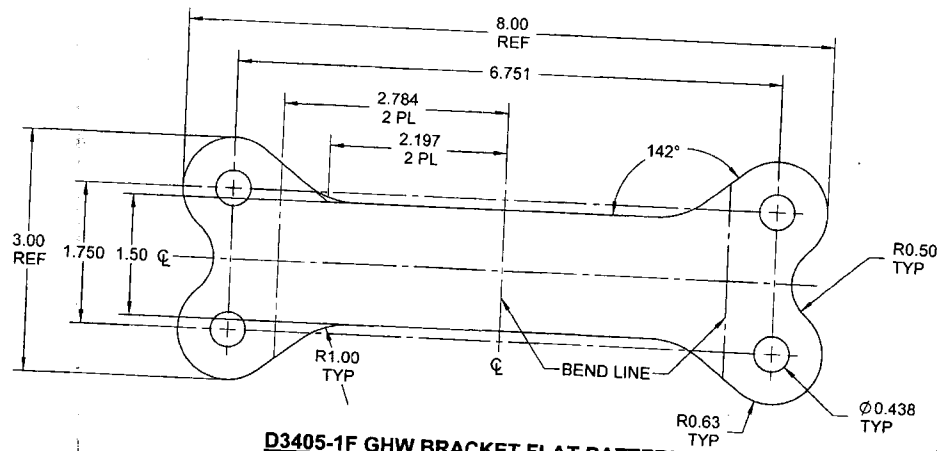
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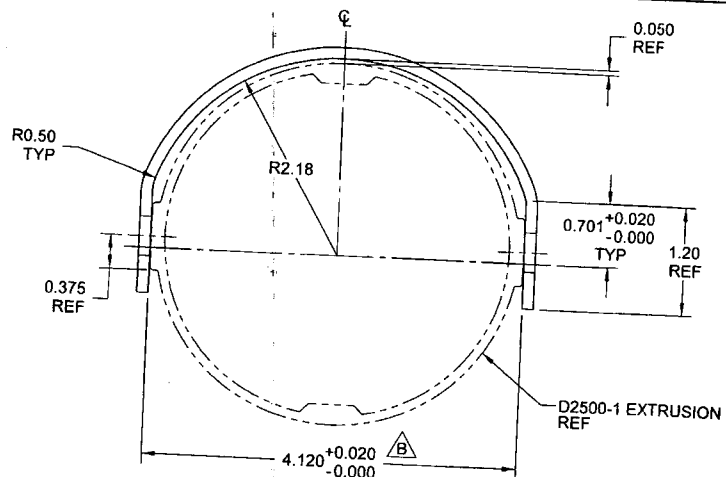
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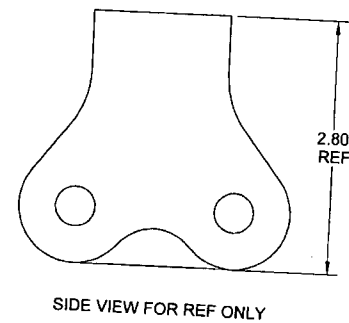
NOTE: Date & initial all entries



D3405-1F GHW BRACKET FLAT PATTERN



D3405-1 GHW BRACKET
(MAKE FROM D3405-1F)



SIDE VIEW FOR REF ONLY

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S11GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	AJS	
CHECKED		DRAWING NO. D3405
MFG. APPR.		REV. B
APPROVED		SHEET 3 OF 4
DE APPR.		TITLE GHW LUG ASSEMBLY
DATE	08.09.19	SCALE NTS

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W/O 57726

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08/09/19

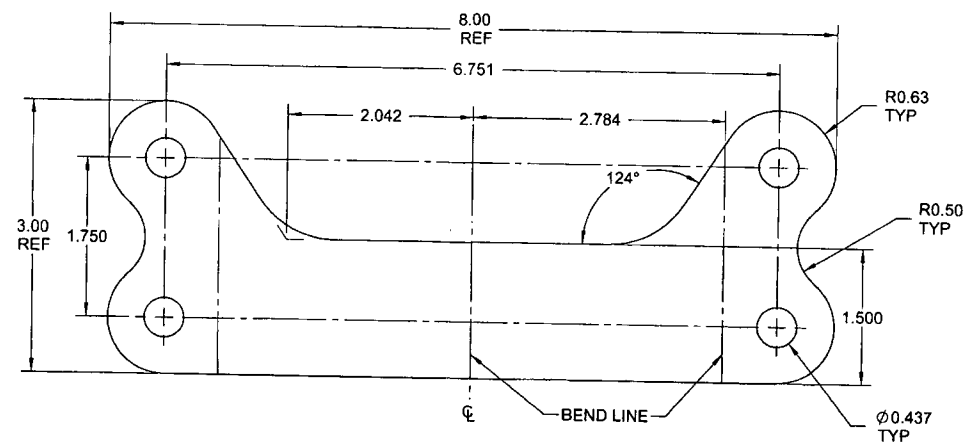
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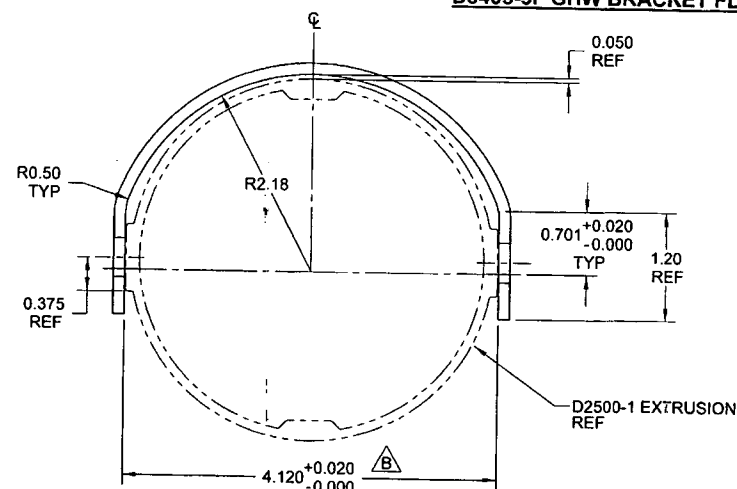
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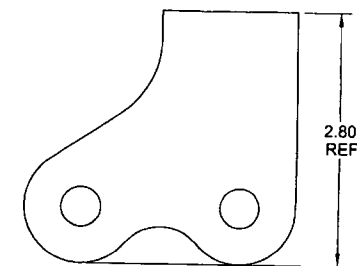
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D3405-3F GHW BRACKET FLAT PATTERN



D3405-3 GHW BRACKET
(MAKE FROM D3405-3F)




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- 7) WEIGHT: N/A

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08/12/18

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